

Work Order ID 126537-28 *28*

126537

Ship Nov

DQA:

Thursday, November 13, 2014 8:35:09 AM

Item ID: D3779-041

Accept

N900040100

Setup Start *N...

Revision ID:

Stop *NS2*

Item Name: Handle Assembly (Exterior)

Start Date: 11/17/14 Start Qty: 26.00 *4*

26

Cust Item ID:

Required Date: 11/20/14 Req'd Qty: 26.00

26

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: *[Signature]*

Date: 14-11-12 Tooling:

Date:

Stop *NR2*

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3779	C

00	FLOW WATER JET	0.00
----	----------------	------

100

Waterjet

LOW CNC Waterjet

2061-125

Memo

1-Cut as per Dwg D3779-1

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

10	QC2- Inspect parts off machine FAI/FAIB	0.00
----	---	------

110

QC

Quality Control

Memo

120	QC8- Inspect parts - second check	0.00
-----	-----------------------------------	------

120

QC

Quality Control

Memo

DAS
23
9-89

14-11-13

DAS
23
9-89

14-11-13

DAS
38
9-89

NOV 13 2014

Work Order ID 126537

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Page 2

Item ID: D3779-041

Revision ID:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Item Name: Handle Assembly (Exterior)

Start Date: 11/17/14

Start Qty: 26.00

26

Required Date: 11/20/14

Req'd Qty: 26.00

26

Reference:

Cust ItemID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

130

Small Fab

Small Fab

0.00

Small Fab

Memo

1- Counter sink holes as per dwg D3779
2- Deburr

0.00

28x 14/11/17

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

28

DAS
38
9-89

NOV 17 2014

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

28 14-11-19

Work Order ID 126537

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Page 3

Item ID: D3779-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Handle Assembly (Exterior)
 Start Date: 11/17/14 Start Qty: 26.00 ***26*** Cust Item ID:
 Required Date: 11/20/14 Req'd Qty: 26.00 ***26*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00			DAS 30 9-89	4	FF		NOV 19 2014
180 *180* Small Fab Small Fab	Small Fab Memo 1- Rivet handle to D3779-1 plate as per dwg D3779 per QSI003	0.00 0.00				4	FF		NOV 19 2014
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				④			DAS 38 9-89 NOV 19 2014 DAS 49 9-89

Work Order ID 126537

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Page 4

Item ID: D3779-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Handle Assembly (Exterior)
Start Date: 11/17/14 Start Qty: 26.00 ***26*** Cust Item ID:
Required Date: 11/20/14 Req'd Qty: 26.00 ***26*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>S1514</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

4 495 636 8985 NOV 19 2014

11/11/2014

11-19

Picklist Print

Thursday, November 13, 2014 8:35:14 AM

Page 1

Work Order ID: 126537

126537

Parent Item: D3779-041

D3779-041

Parent Item Name: Handle Assembly (Exterior)

Start Date: 11/17/14

Required Date: 11/20/14

Start Qty: 26.00

Required Qty: 26.00

Comments:

IPP Rev:A 08-06-09 new issue DD verified by:ec
 IPP Rev:B 08-07-21 procedure change DD verified by:EC IPP Rev:C
 11.12.02 as per dwg revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.125

Purchased

No

100

sf

149.3910

0.194

6

DAS

M6061T6S 125

6061-T6 .125 Sheet

**

23
9-89

14-11-13

Location

Loc Qty

Loc Code

MAT021

149.391

m127272

29.2

m127454

24.703

m127501

5.1

m128852

6.938

m130524

21.45

m130745

62

130745

D3779-7

Manufactured

No

180

Each

0.0000

1

26

D3779-7

Handle

**

NOV 19 2014

MS20426AD10-9A

Purchased

No

180

Each

118.0000

4

104

MS20426AD10-9A

RIVET

**

NOV 19 2014

Location

Loc Qty

Loc Code

ST311

118

125170

1

M127659

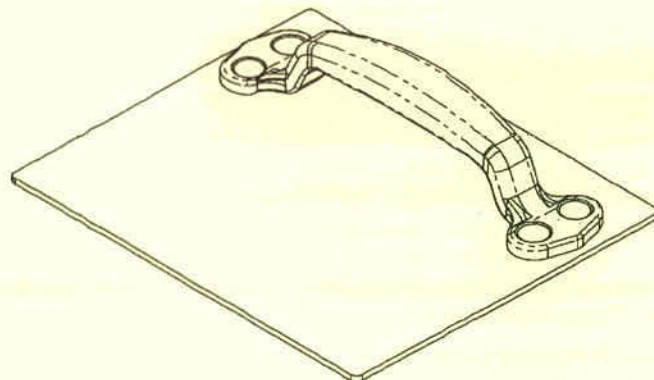
17

M130862

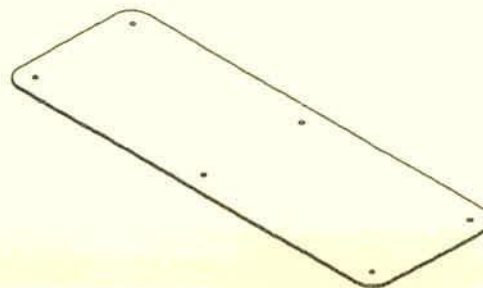
100

16

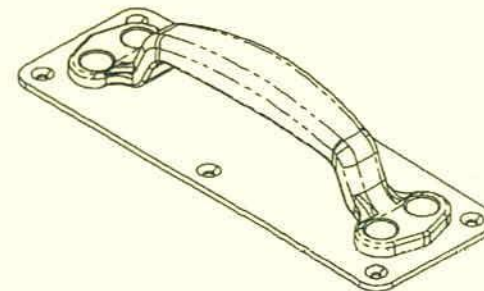
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
1		D3779-7	HANDLE
4	4	MS20426AD10-9A	RIVET, CSK



**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**



D3779-3 DOUBLER PLATE



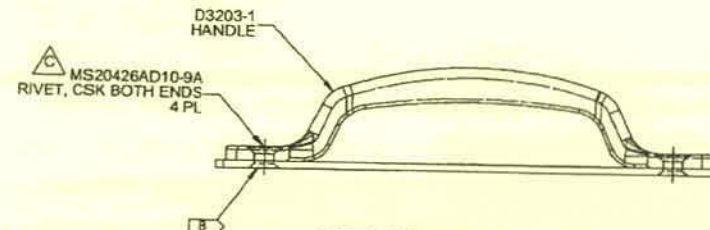
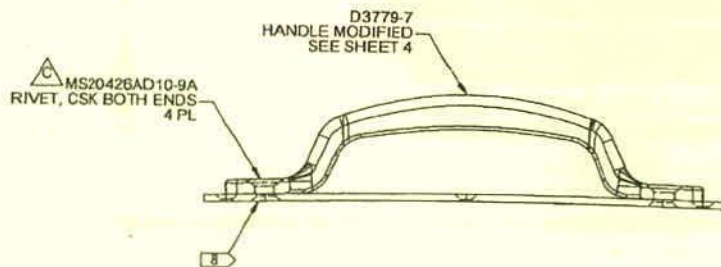
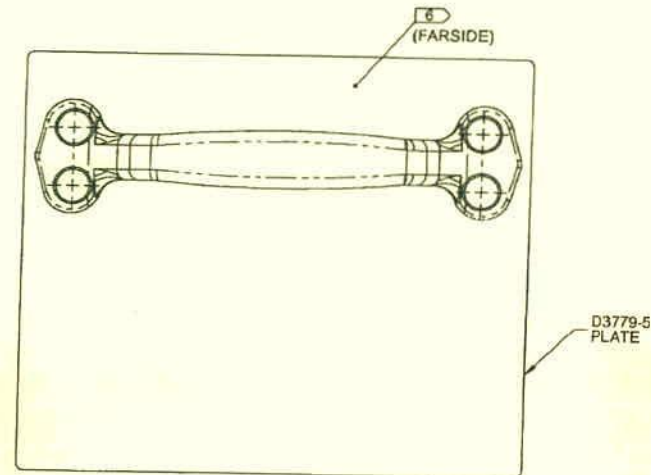
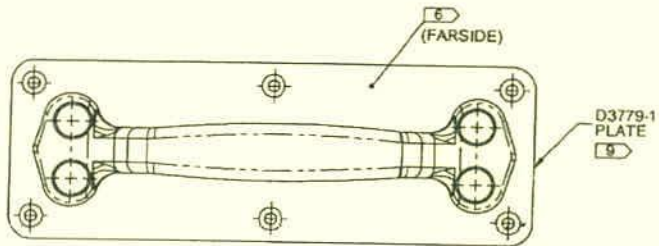
**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: (SEE SHEETS 2 & 3)
 - 7) WEIGHT: D3779-3: 0.14 lbs
D3779-041: 0.71 lbs
D3779-043: 1.14 lbs

Handwritten: 126537

RELEASED
2012-07-23
Handwritten initials: JNP

REV.	DESCRIPTION	BY	DATE
C	CHANGED RIVET FROM -8 TO -9A CHANGED D3779-041 FROM FLAT TO CONTOURED	RP	12.04.26
B	REFORMAT IAW DART QSI 043: MS20426AD10-9 WAS MS20426AD10-8 (2N D6-1, B8/B4-2) REASON: PRODUCTION FACILITY (PAR11-136)	MB	11.11.24
A	NEW ISSUE	AJS	08.04.21
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3779 TITLE HANDLE ASSEMBLY, CABIN SLIDING DOOR SCALE NTS SHEET 1 OF 4 REV. C COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION THAT IS UNCLASSIFIED OR CONTROLLED UNDER THE ACCESS TO INFORMATION ACT</small>	
DRAWN	RP		
CHECKED	A.P.		
MFG. APPR.	GP		
APPROVED	MP		
DE APPR.	MP		
DATE	12.04.26		



**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**

**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**

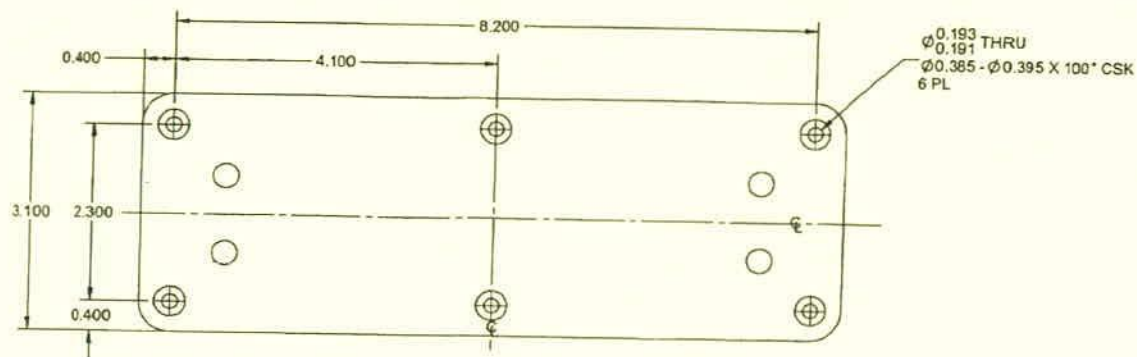
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-XXX" AND B/N "BXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: D3779-041: 0.71 lbs
D3779-043: 1.14 lbs
- 8) RIVETS TO BE PEENED AND GROUND FLUSH.
- 9) FORMED TO FIT D3779-7 HANDLE DURING ASSEMBLY.

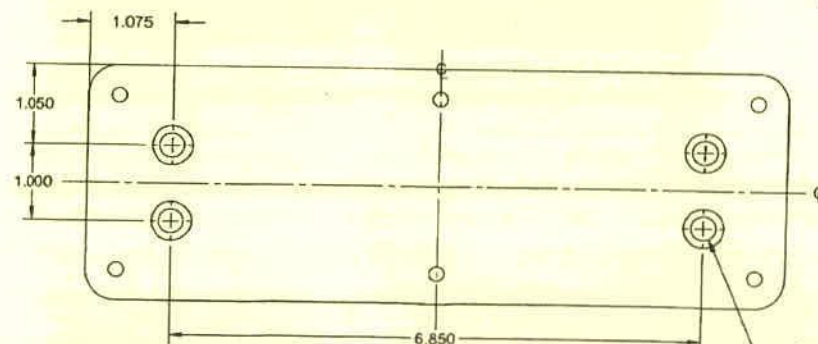
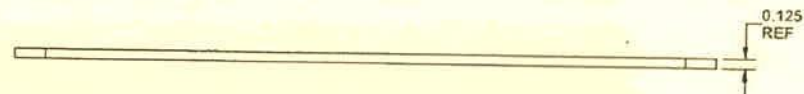
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2012-07-23

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	EP	D3779	SHEET 2 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	HANDLE ASSEMBLY,	NTS
DATE	12.04.26	CABIN SLIDING DOOR	

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Ø0.193 THRU
Ø0.191
Ø0.385 - Ø0.395 X 100° CSK
6 PL



Ø0.322 THRU
Ø0.316
Ø0.515 - Ø0.525 X 100° CSK
4 PL

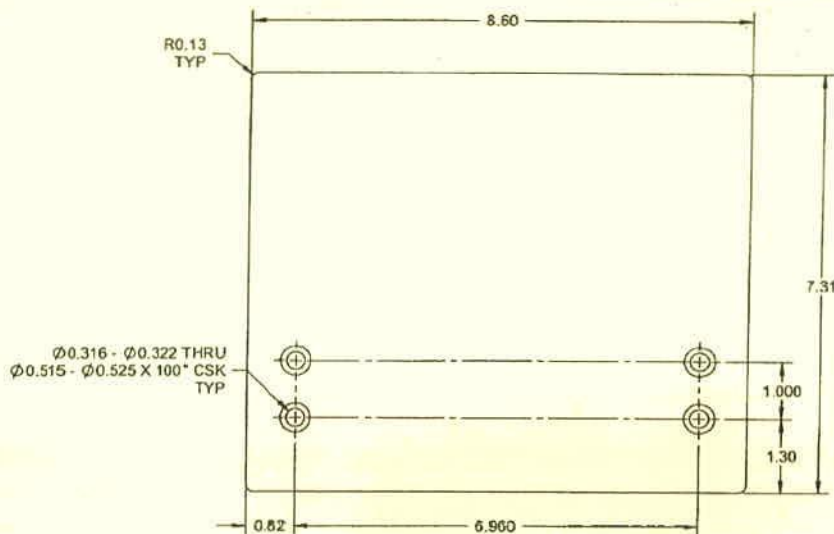
D3779-1 PLATE

NOTES:

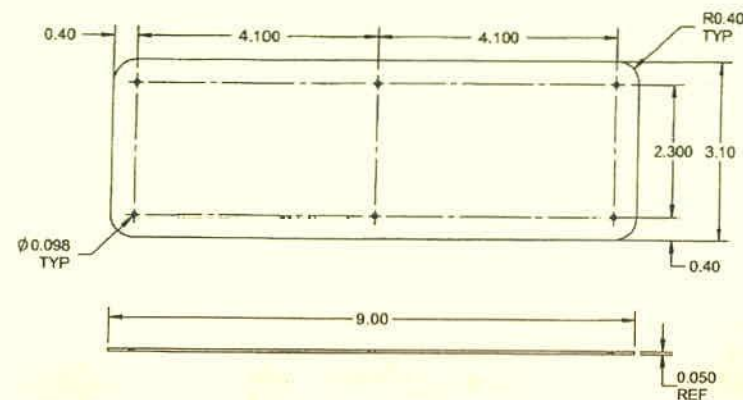
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	G.D.	D3779	SHEET 3 OF 4
APPROVED	W.L.	TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY,	NTS
DATE	12.04.26	CABIN SLIDING DOOR	
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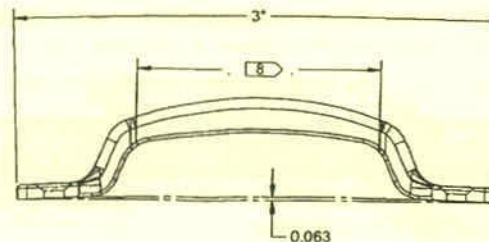
RELEASED
2012-07-23
JMS



D3779-5 PLATE



D3779-3 DOUBLER PLATE



D3779-7 HANDLE, MODIFIED

NOTES:

1) MATERIAL:

D3779-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.050)

D3779-5: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027
(REF DART SPEC M6061T6S.125)

D3779-7: MADE FROM D3203-1

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: D3779-3: IDENTIFY WITH DART P/N "D3779-3" AND B/N "BXXXXX" PER DART QSI 044 6.1

△ D3779-5: NONE
△ D3779-7: NONE

7) WEIGHT: D3779-3: 0.14 lbs

D3779-5: 0.76 lbs

D3779-7: 0.38 lbs

8) BEND HANDLE THROUGH THIS AREA ONLY △

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2012-07-23

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DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.		D3779	SHEET 4 OF 4
APPROVED	WJ	TITLE	HANDLE ASSEMBLY, SCALE
DE APPR.		CABIN SLIDING DOOR	NTS
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